

Work Order ID 93324

93324

Page 1

November-15-12 11:38:33 AM

Item ID: D3849-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate

Start Date: 11/15/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12-11-12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3849	D								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3849 Dwg Rev: D Prog Rev: D								
304.050									
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(8)

12-11-12

(8)

12-11-12

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other					
Part No. _____ NCR No. _____												
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other

Work Order ID 93324

93324

Page 2

November-15-12 11:38:33 AM

Item ID: D3849-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate

Start Date: 11/15/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

AS
15
9-03

8

130

130

Brake NC

Brake NC

Memo

0.00

10 11 24

8

8
13/01/03

210

210

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

AS
15
9-03

0.00

10 01 03

8

NCR: Yes / No

WORK ORDER NON-COMPLIANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>								
Part No. _____															
NCR No. _____															
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
														<input type="checkbox"/> Other	

Work Order ID 93324

93324

Page 3

November-15-12 11:38:33 AM

Item ID: D3849-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 11/15/12 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

220

Packaging

Packaging

Identify as per dwg & Stock Location: WA001

0.00

8

13-01-03 MAL

230

230

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/1/10 SJ

PLB014

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date: ,

QA Closed: _____ Date: _____

Picklist Print

November-15-12 11:38:32 AM

Page 1

Work Order ID: 93324

Parent Item: D3849-3

Parent Item Name: Plate

Start Date: 11/15/12

Required Date: 11/30/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
REV.D DD VERF:JLM

IPP Rev:B 12.09.11 AS PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	300.8149	3.585	30.189474		B(2-11-23)	

Location	Loc Qty	Loc Code
MAT020	300.814947	
121626	1.65	
121660	11.000737	
123155	45.56421	
123279	31.4	
123372	19.2	
123649	192	123649

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
		Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other					

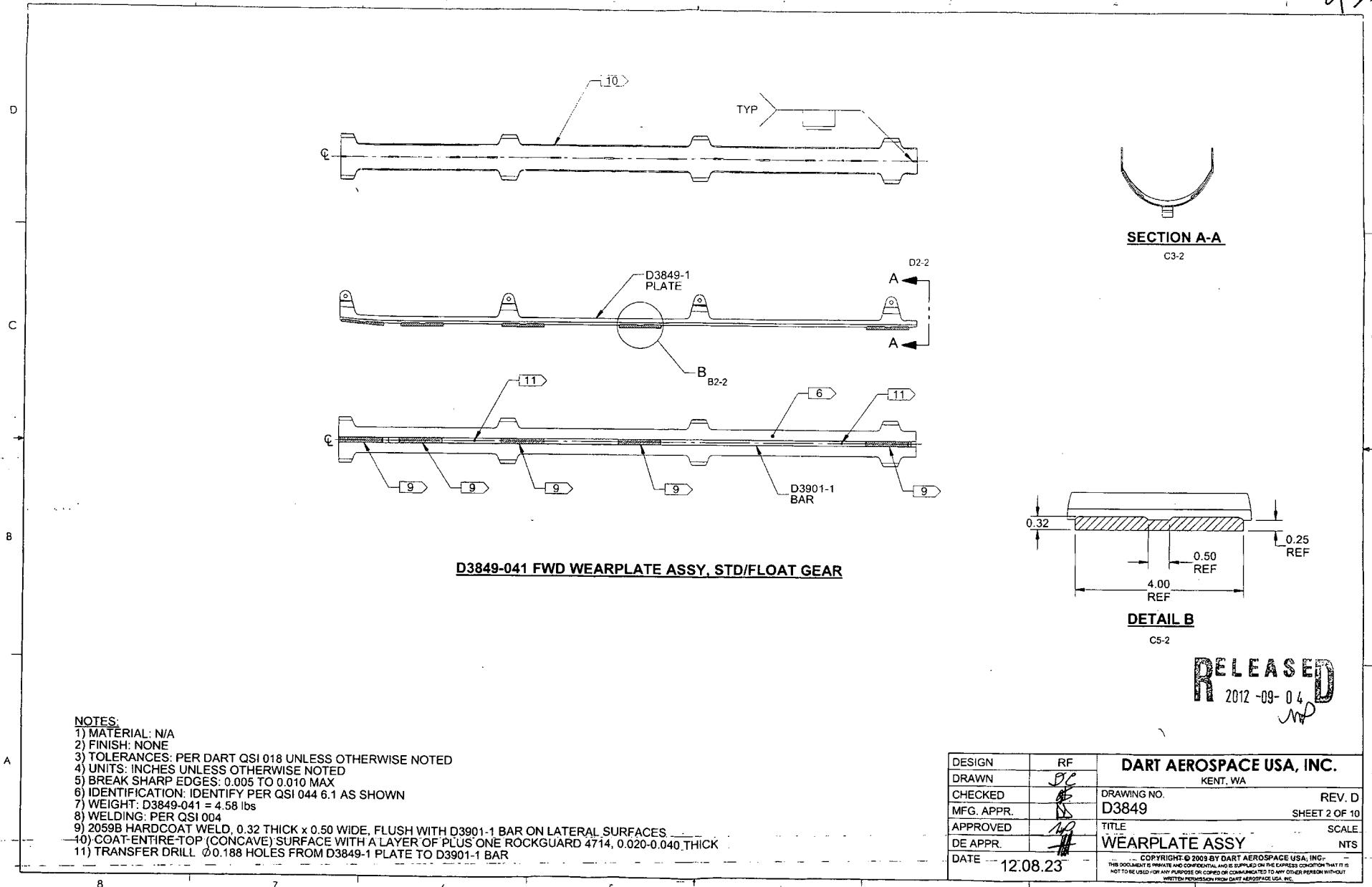
DART AEROSPACE LTD	Work Order:	93324
Description: PLATE	Part Number:	D3849-3
Inspection Dwg: D38493 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

A
15

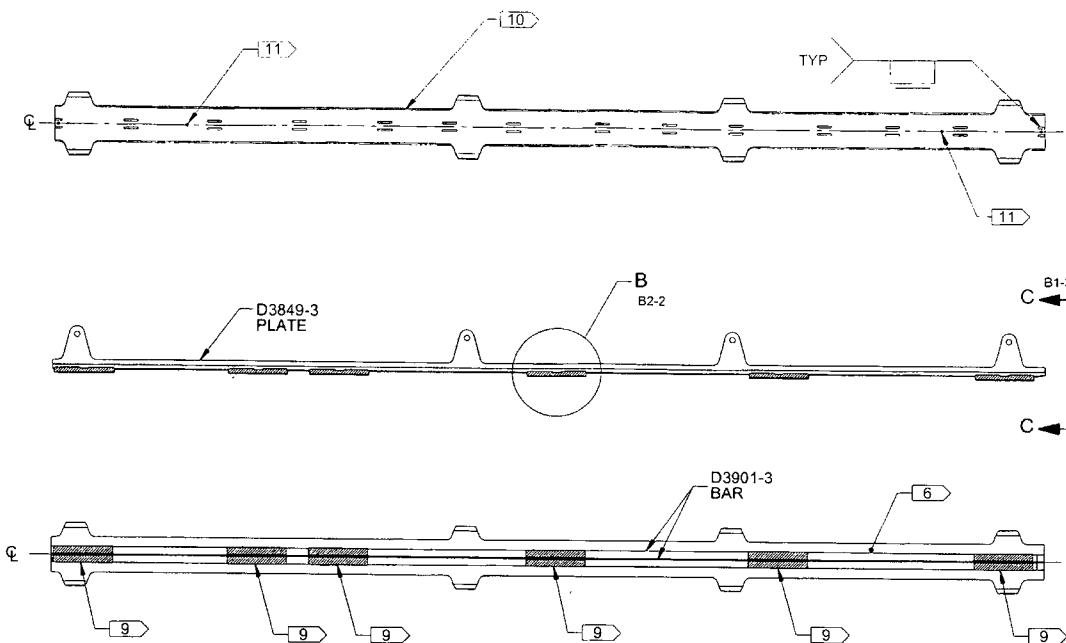
Measured by:	RB	Qualified by:	15 69	Preliminary Approval:
Date:	12-11-23	Date:	12-11-26	Date:

93324



RELEASED
2012-09-04
JW

93324

D3849-043 AFT WEARPLATE ASSY, STD GEAR

NOTES:

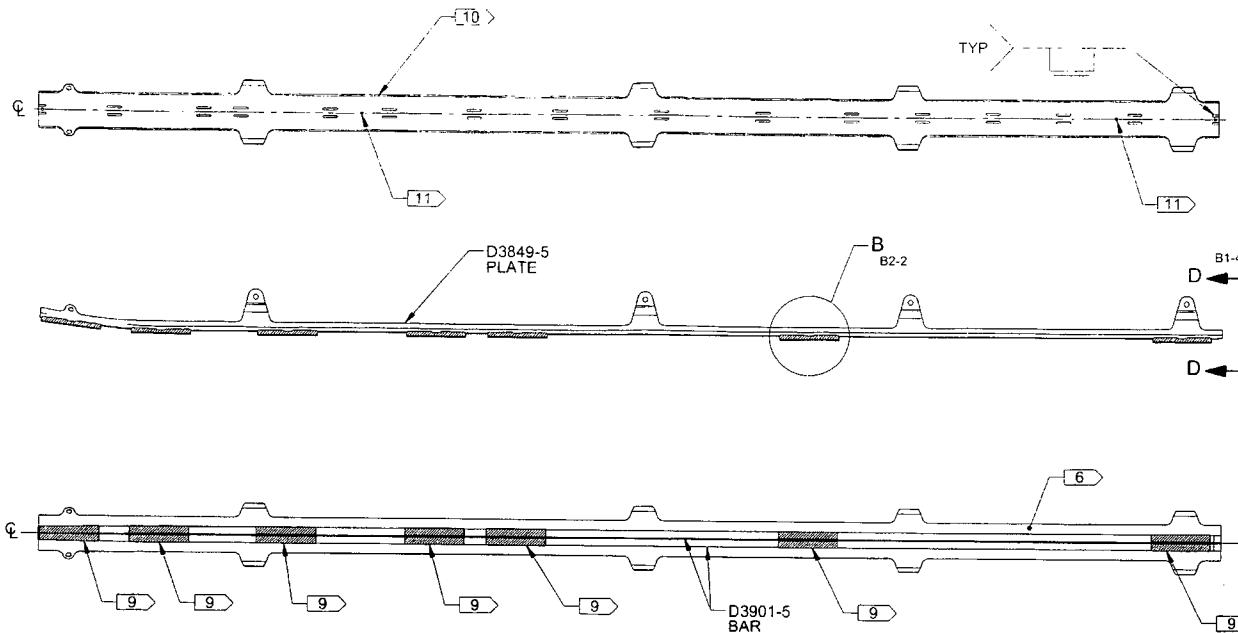
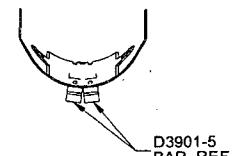
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-043 = 7.66 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD-4714, 0.020-0.040-THICK
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BARS

DESIGN DRAWN	RF <i>DC</i>	DART AEROSPACE USA, INC.	
CHECKED	<i>BS</i>	KENT, WA	
MFG. APPR.	<i>NA</i>	DRAWING NO. D3849	REV. D SHEET 3 OF 10
APPROVED	<i>NA</i>	TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.	<i>#</i>	DATE 12.08.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

SECTION C-C
RELEASED
2012-09-04
MM

8 7 6 5 4 3 2 1

93324

D3849-045 AFT WEARPLATE ASSY, FLOAT GEARRELEASED
2012-09-04SECTION D-D

C2-4

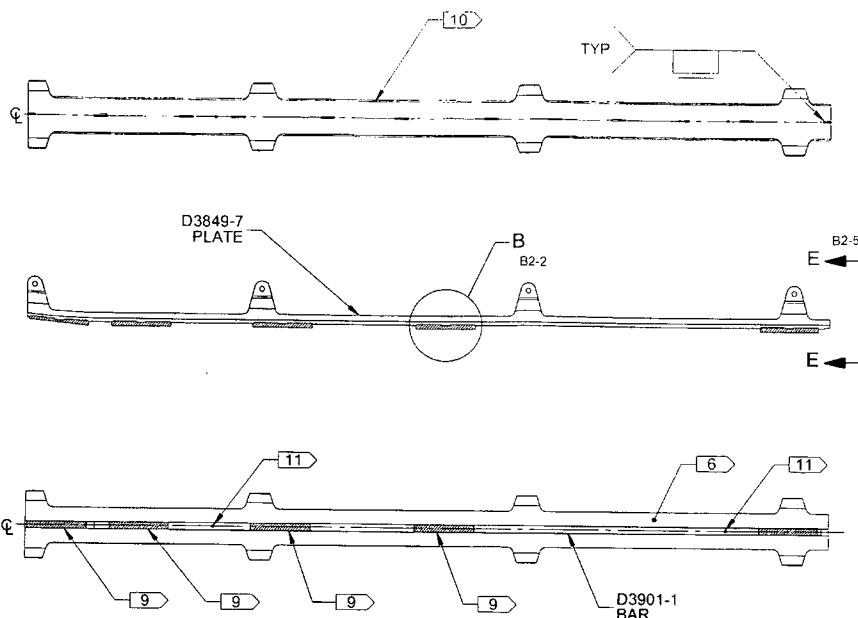
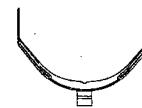
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-045 = 8.93 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL Ø 0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BARS

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	JPC	KENT, WA
CHECKED		
MFG. APPR.	X	
APPROVED		
DE APPR.		
DATE	12.08.23	SCALE NTS
DRAWING NO. D3849 REV. D		
SHEET 4 OF 10		
TITLE WEARPLATE ASSY		
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8 7 6 5 4 3 2 1

93324

D3849-047 FWD WEARPLATE ASSY, FLOAT GEARSECTION E-E

C3-5

RELEASED
2012-09-04
[Handwritten signature]

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-047 = 4.60 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL Ø 0.188 HOLES FROM D3849-7 PLATE TO D3901-1 BAR

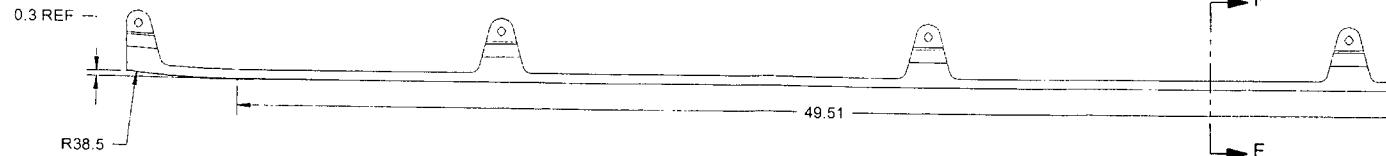
8 7 6 5 4 3 2 1

DART AEROSPACE USA, INC.	
KENT, WA	
DESIGN	RF
DRAWN	<i>JLC</i>
CHECKED	<i>[Signature]</i>
MFG. APPR.	<i>[Signature]</i>
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	12.08.23

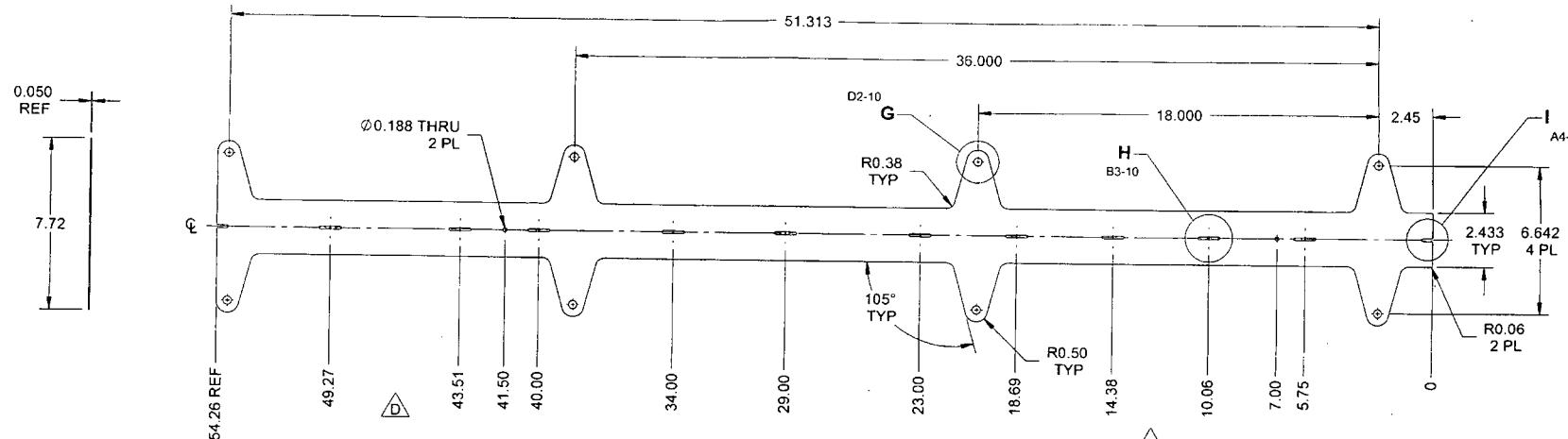
REV. D
DRAWING NO.
D3849
SHEET 5 OF 10
TITLE
WEARPLATE ASSY
SCALE
NTS

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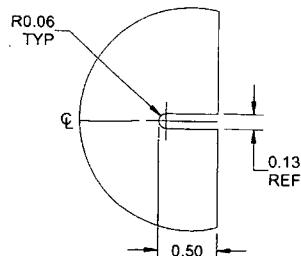
93324



D3849-1 PLATE
(MAKE FROM D3849-1F)



D3849-1F FLAT PATTERN



DETAIL I

C2-6
B2-9

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.30 lbs

8

7

6

5

4

3

2

1

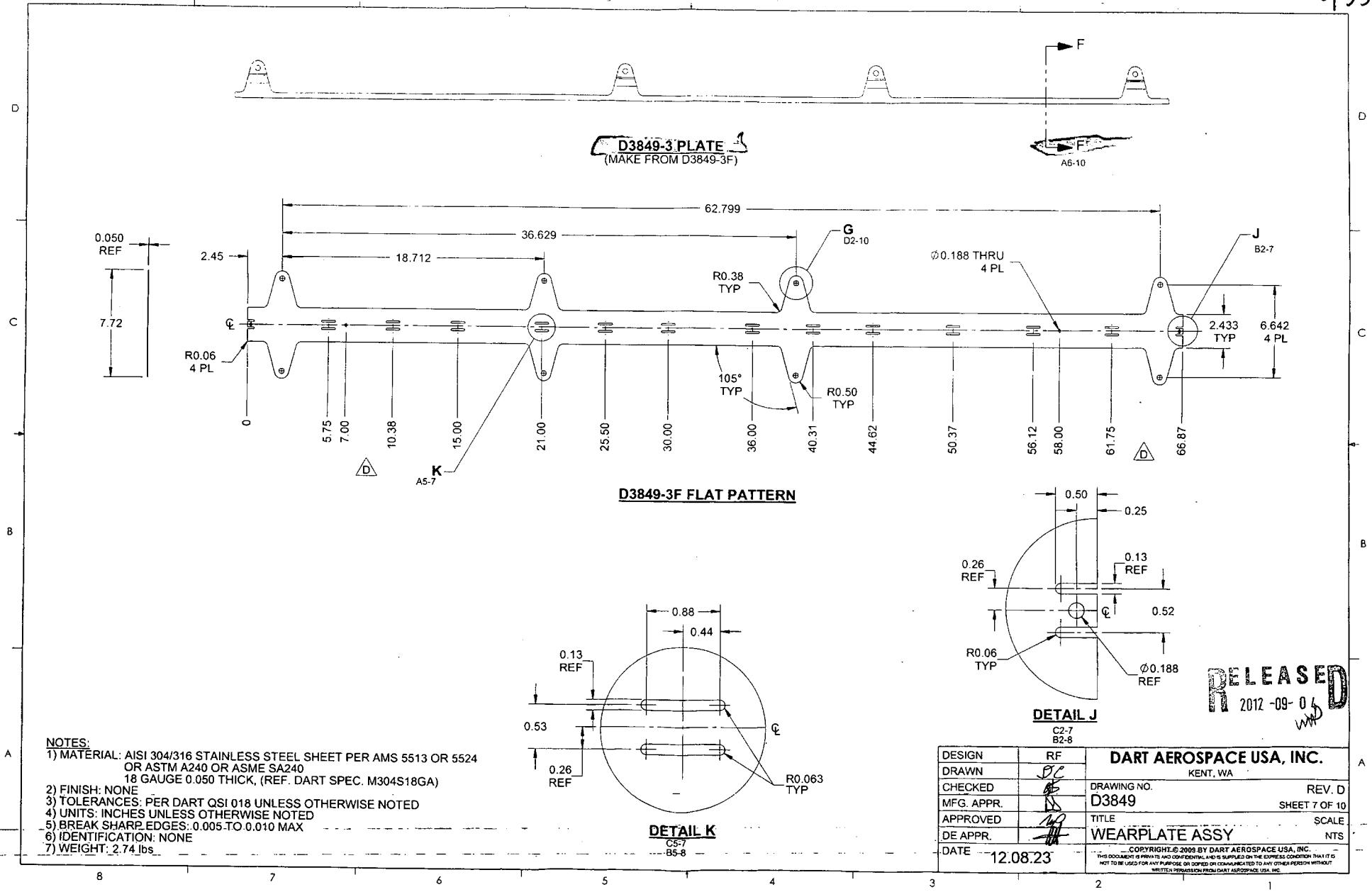
A

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	DC	KENT, WA
CHECKED	BS	DRAWING NO.
MFG. APPR.	PA	REV. D
APPROVED	MM	D3849
DE APPR.	#	SHEET 6 OF 10
DATE	12.08.23	TITLE
		WEARPLATE ASSY
		NTS

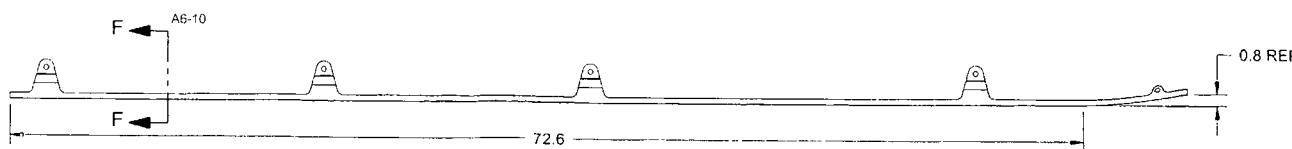
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RELEASE
2012-09-04

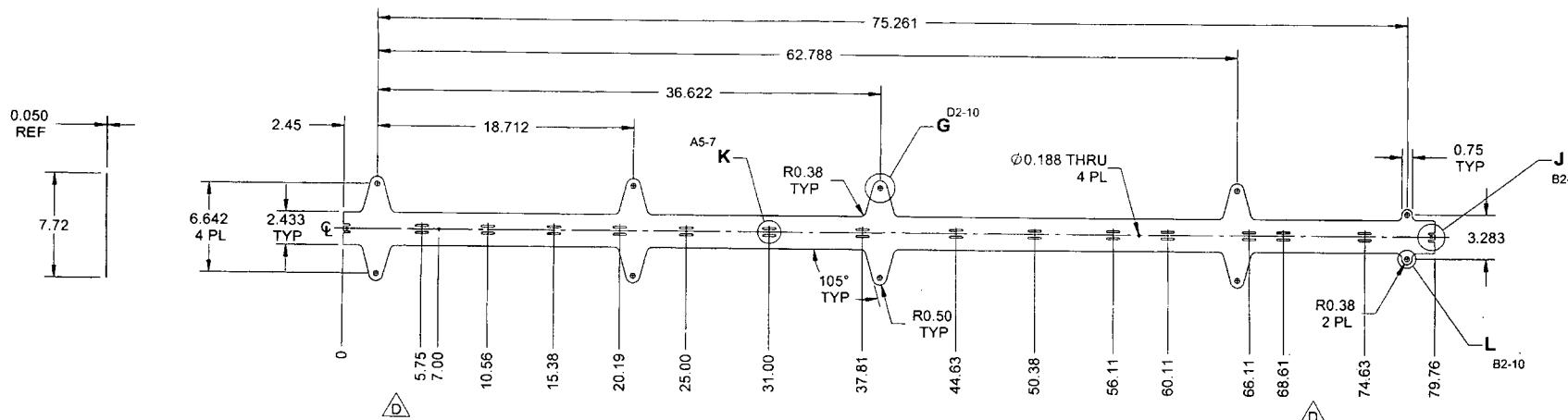
93324



93324



D3849-5 PLATE
(MAKE FROM D3849-5F)



D3849-5F FLAT PATTERN

RELEASED
2012-09-04
SN

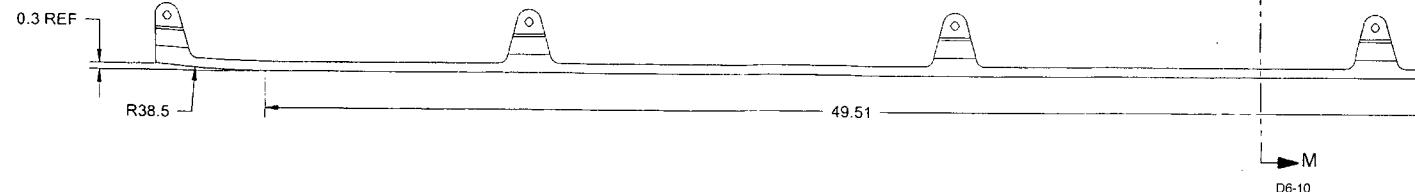
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK. (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.17 lbs

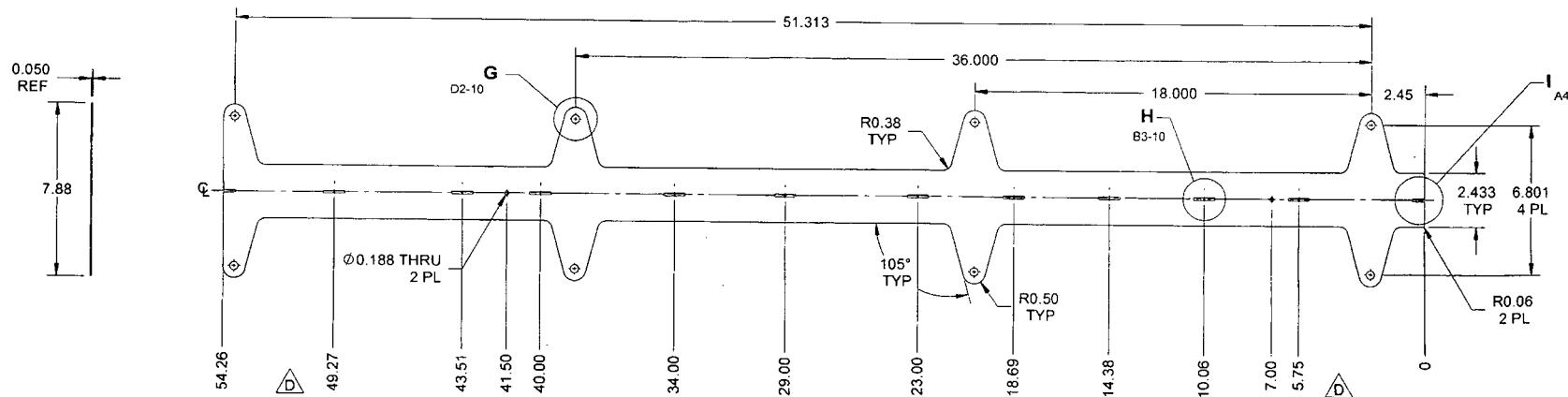
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	PL	KENT, WA	
CHECKED		DRAWING NO. REV. D	
MFG. APPR.		D3849 SHEET 8 OF 10	
APPROVED		TITLE	
DE APPR.		SCALE	
DATE	12.08.23	WEARPLATE ASSY NTS	

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93324



D3849-7 PLATE
(MAKE FROM D3849-7F)



D3849-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.32 lbs

8

7

6

5

4

3

2

1

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	<i>JL</i>	KENT, WA
CHECKED	<i>AS</i>	DRAWING NO.
MFG. APPR.	<i>NA</i>	REV. D
APPROVED	<i>WJ</i>	D3849
DE APPR.	<i>WJ</i>	SHEET 9 OF 10
DATE	12.08.23	TITLE WEARPLATE ASSY SCALE NTS

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RELEASED
2012-09-04
[Signature]

93324

